



Dart Aerospace Ltd.
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D5350-041
Job Sheet 184783



Part No: D5350-041

Job Qty: 3 ea

Part Name: Fwd Cross Beam Assembly



Part Weight: 0 lbs

Status: New

Priority: High

Job Created: 10/17/18

Job Tracking No:

Due Date: 10/19/18

Created By: Jason Leroux

Type: SOLD

Description:

Note: DWG REV D SHEET 1 IPP REV:A 15.12.11 NEW ISSUE DD VERF:JLM IPP REV:B 16.01.25 rev.a dwg DD
VERF:JLM IPP REV:C 16.06.30 DWG REV.B DD VERF:JLM IPP REV:D 17.01.09 DWG REV.c DD VERF:JLM
IPP REV:E DWG. REV.D 17/04/11 JFS VERIFIED BY: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea	10/19/18	10/19/18	0.00	0.00	Start Up Machining-4		<i>lll</i>
100	Bandsaw	3 pcs	10/19/18	10/19/18	0.00	0.12	Bandsaw1		<i>lll</i>
110	CNC Vertical Machining	3 pcs	10/19/18	10/19/18	1.26	6.67	HAAS1-2		<i>lll</i>
120	QC	3 pcs	10/19/18	10/19/18	0.00	0.00	QC2 Machining-4		<i>lll</i>
130	Mill Conv	3 pcs	10/19/18	10/19/18	0.00	6.00	Mill Conv 1		<i>ll</i>
140	QC	3 pcs	10/19/18	10/19/18	0.00	0.00	QC8		<i>lll</i>
150	Skidtubes	3 pcs	10/19/18	10/19/18	0.00	0.32	Skidtubes-3		<i>lll</i>
160	QC	3 pcs	10/19/18	10/19/18	0.00	0.00	QC5		<i>lll</i>
170	HandFinish	3 pcs	10/19/18	10/19/18	0.00	0.30	HandFinish1		<i>lll</i>
180	QC	3 pcs	10/19/18	10/19/18	0.00	0.00	QC7-5		<i>lll</i>
190	Powdercoat	3 pcs	10/19/18	10/19/18	0.00	0.30	Powdercoat1		<i>lll</i>
200	QC	3 pcs	10/19/18	10/19/18	0.00	0.00	QC3		<i>lll</i>
210	Small Fab	3 pcs	10/19/18	10/19/18	0.00	1.40	Small Fab-9		<i>lll</i>
220	QC	3 pcs	10/19/18	10/19/18	0.00	0.00	QC5		<i>lll</i>
230	Packaging	3 pcs	10/19/18	10/19/18	0.00	0.00	Packaging3-2		<i>lll</i>
240	QC21-SA	3 Ea	10/19/18	10/19/18	0.00	0.00	QC21		<i>lll</i>

5115941 → 2x
M 138951.

START: 8:40

OUT: 320° FINISH: 9:10.

DAS 9-89
21
9-89

NOV 27 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X06.000	6061T6 Bar 1.00 X 6.00	17.3250 ft (5.775 ea)	90-Start up Operation	
AN3-13A	Bolt	6 Ea (2 ea)	210-Small Fab	5098032
CBL-1240	Cable	16.2600 ft (5.42 ea)	210-Small Fab	5032661
CBL-460	Loop Sleeve	30 Ea (10 ea)	210-Small Fab	5119332
D5324-3	Bracket	13 Ea (1 ea)	210-Small Fab	5007586
D5346-3	Bushing	442 Ea (4 ea)	210-Small Fab	5108082
D5350-5	Adapter	13 Ea (1 ea)	210-Small Fab	5098062
MS17984-C412	Pin, Quick Release	28 Ea (2 ea)	210-Small Fab	5090932
MS17984-C418	Quick Release Pin	13 pcs (1 ea)	210-Small Fab	5036480
MS17984-C517	Pin, Quick Release	28 Ea (2 ea)	210-Small Fab	5000375
MS21042L3	Nut	26 Ea (2 ea)	210-Small Fab	094582
NAS1149D0316J	Washer	442 Ea (4 ea)	210-Small Fab	5037584-1
				PM134502-2

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.000X06.000	17	57	0
210-Small Fab	AN3-13A	6	97	0
	CBL-1240	16	344	0
	CBL-460	30	193	0
	D5324-3	3	57	0
	D5346-3	12	17	0
	D5350-5	3	11	0
	MS17984-C412	6	15	0
	MS17984-C418	3	29	0
	MS17984-C517	6	38	0
	MS21042L3	6	2,637	0
	NAS1149D0316J	12	584	0

Part Specifications

Specifications could not be found.

Plex 10/17/18 8:15 AM dart.leroux.jason

DART
AEROSPACE

Container No: S120592

Part: D5350-041

Job No: 184783

Serial No/Batch: S120592

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/23/18

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DART AEROSPACE LTD		Work Order:	
Description: Fwd Beam		Part Number:	D5350-1
Inspection Dwg: D5350 Rev: D		Page 1 of 2	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.006/-0.001	258.8	✓		Ping gauge	
0.40	+/-0.030	400	✓		high gage	
1.00	+/-0.030	998	✓		high gage	
1.20	+/-0.030	1199	✓		high gage	
2.00	+/-0.030	2001	✓		high gage	
0.65	+/-0.030	650	✓		Vernier	
3.15	+/-0.030	3150	✓		Vernier	
0.716	+0.010/-0.020	715	✓			
37.20	+/-0.030	37.200	✓		tape	
39.70	+/-0.030	39.700	✓		tape	
0.300	+/-0.010	297	✓		vernier	
0.25	+/-0.030	247	✓		vernier	
0.280	+0.015/-0.005	277	✓		high gage	
12.000	+/-0.005	11999	✓		Vernier	12 gage
9.06	+/-0.030	9066	✓		Vernier	
0.62	+/-0.030	619	✓		Vernier	
0.80	+/-0.030	801	✓		Vernier	
5.22	+/-0.030	522	✓		high gage	
4.05	+/-0.030	4044	✓		high gage	
2.55	+/-0.030	255	✓		high gage	
0.30	+/-0.030	300	✓		high gage	
0.35	+/-0.030	349	✓		high gage	
0.750	+/-0.005	748	✓		vernier	
0.55	+/-0.030	550	✓		high gage	
1.00	+/-0.030	1004	✓		high gage	
0.550	+/-0.010	554	✓		vernier	
0.225	+/-0.010	222	✓		vernier	
Ø0.325	+0.006/-0.001					
1.00	+0.030/-0.000					
0.600	+/-0.005					
0.045 x 45°	+/-0.015 x +/-0.5°	1050 x 45°	✓		vernier	
2.05	+0.030/-0.010	2049	✓		high gage	
1.030	+0.015/-0.000	1034	✓		vernier	
0.250	+0.015/-0.010	1250	✓		vernier	
0.480	+/-0.015					
Ø0.375	+0.004/-0.010	374.8	✓		Ping gauge	
0.415 x 90°	+/-0.010 x +/-0.5°	425 x 90°	✓		vernier	
4.23	+/-0.030	4226	✓		vernier	
0.30	+/-0.030	298	✓		vernier	

DART AEROSPACE LTD		Work Order:	
Description: Fwd Beam		Part Number:	D5350-1
Inspection Dwg: D5350	Rev: D	Page 2 of 2	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.25	+/-0.030	1247	✓		Vernier	
Ø0.204	+0.005/-0.001	12048	✓		Ring gauge	
0.30	+/-0.030	1298	✓		Vernier	
2.50	+/-0.030	2499	✓		Vernier	
66.78	+/-0.030	66.785	✓		Tap	
0.25	+/-0.030	1250	✓		Vernier	
0.51 - 0.45	N/A					
2.50	+/-0.030	2.500	✓		Vernier	
0.50	+/-0.020	1501	✓		Vernier	
1.50	+/-0.030	1500	✓		Vernier	
1.30	+/-0.030	1302	✓		Vernier	

Measured by:	<i>mm</i>	Checked by:	<i>mm</i>	QC Inspector:	
Date:	<i>2018/19/10</i>	Date:	<i>18/10/20</i>	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	17.07.18	New Issue	KJ	<i>[Signature]</i>

